

Date: Wednesday, 2/7/2007 2:36:27 PM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GUIDE ASSEMBLY
Job Number	: 30675		
Estimate Number	: 12709		
P.O. Number	:	Part Number	: D3572041
This Issue	: 2/7/2007 S.O. No. :	Drawing Number	: D3572 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: AC0002
First Issue	: 11 Type LARGE FAB ASSY	Drawing Revision	: U/R
Previous Run	:	Material	:
Written By	: <u>JLM 07-02-07</u>	Due Date	: 2/14/2007 Qty: 2 Um: Each
Checked & Approved By	:		
Comment	: Est Rev: A New Issue 07-02-07 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D35723	GUIDE
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

GUIDE

Batch: B30670

PD 07-02-08 (2)

2.0	D35727	CAP
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

CAP

Batch: B30672

PD 07-02-08 (2)

3.0	D35725	BRACKET
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

BRACKET

Batch: B30671

PD 07-02-08 (2)

4.0	M6061T6TS0750W062	6061-T6 SQ Tube.75x.062W
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Comment: Qty.: 2.3405 f(s)/Unit Total: 4.6809 f(s)

6061-T6 SQ Tube.75x.062W

Batch: M103069

JLM 07-02-07

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D3572

A/R AL ROD

Batch: M100237

2-Blend end Caps.

PD 07-02-08 (2)

Date: Wednesday, 27/2/2007 2:36:28 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE ASSEMBLY

Job Number: 30675

Part Number: D3572041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AA 07/02/08 (2)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

AA 07/02/08 (2)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

am 07/02/08 (2)

9.0

POWDER COATING

POWDER COATING



M 101601



(2x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m.f/a.m 07/02/08

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

1.207/02/08 (2)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

**ENGINEERING
APPROVAL**

HA 07/02/08 (2)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



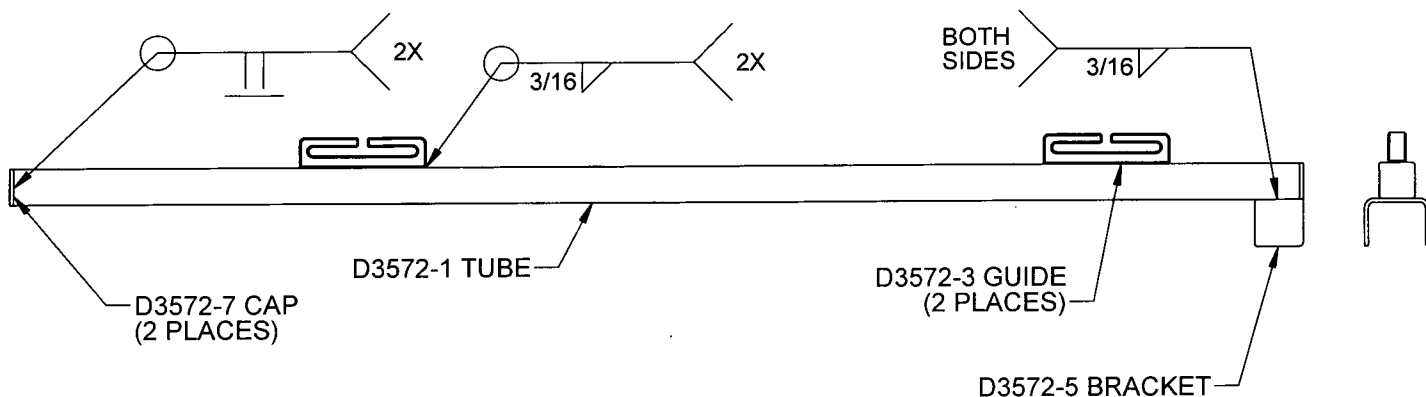
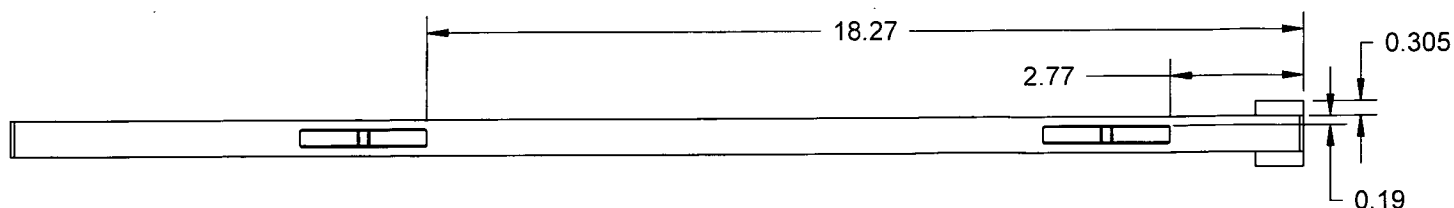
07/02/08

PRELIMINARY ISSUE

UNDER REVIEW

07.02.07 LE

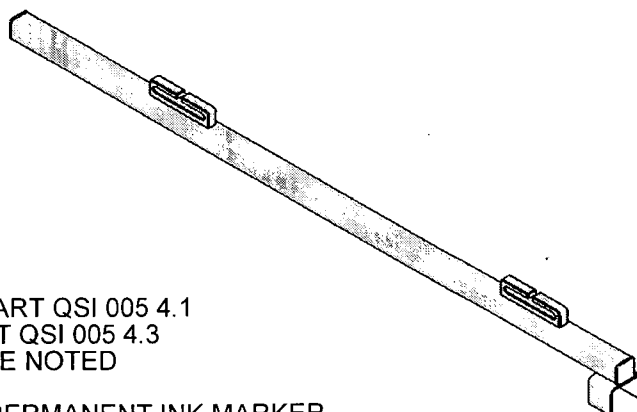
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CHECKED	APPROVED	DRAWING NO. D3572	REV. A SHEET 1 OF 3
DATE 07.02.02		TITLE GUIDE ASSEMBLY	SCALE 1:4
REV A	DATE 07.02.02	DESCRIPTION NEW ISSUE	



D3572-041 GUIDE ASSEMBLY

D3572-041 PARTS LIST:

QTY	P/N	DESCRIPTION
X	D3572-041	GUIDE
1	D3572-1	TUBE
2	D3572-3	GUIDE
1	D3572-5	BRACKET
2	D3572-7	CAP



D3572-041 NOTES:

- 1) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) WELD PER DART QSI 004
- 4) IDENTIFY WITH DART P/N "D3572-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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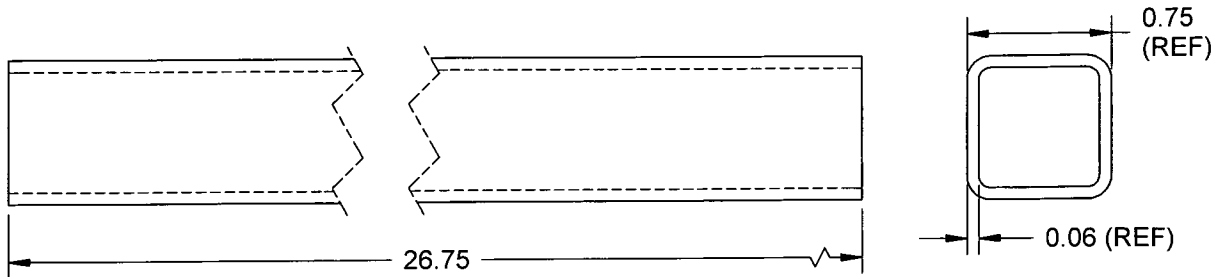
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PRELIMINARY ISSUE

UNDER REVIEW

07.02.07 *LE*

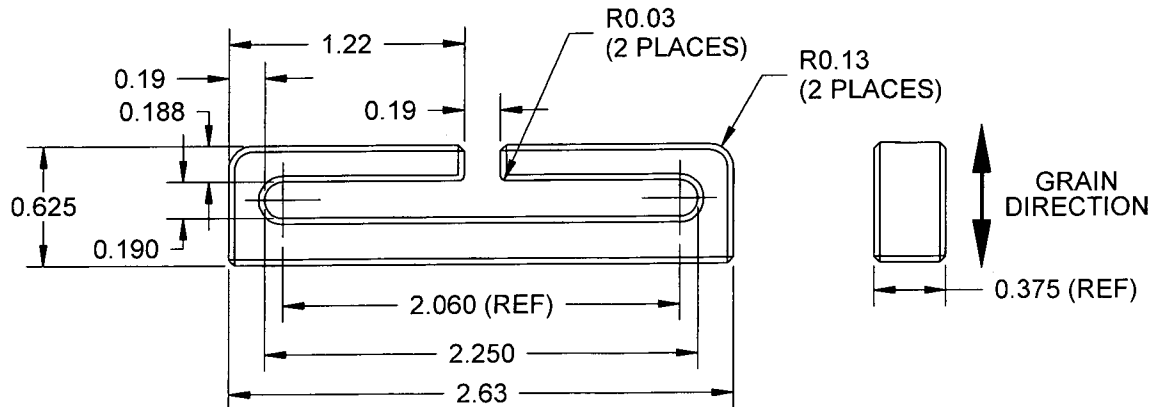
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3572	REV. A SHEET 2 OF 3
DATE 07.02.02	TITLE GUIDE ASSEMBLY		SCALE 1:1



D3572-1 TUBE

D3572-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM SQUARE TUBE 0.750 X 0.062
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6TS0.750W.062)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



D3572-3 GUIDE

D3572-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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